



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3121-144
Job Sheet 169363



Part No: D3121-144

Job Qty: 4 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/8/17

Job Tracking No:

Due Date: 1/3/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Black Tusk Helicopters Ltd (CBLAC03)

PO Box 1469, 46041 Government Road Squamish, BC, V8B 0B1 Canada ph:(604) 898-4800

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by:EC IPP
Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/2/18	0.00	0.00	Start Up Machining-1		17-12-27
100	Bandsaw	4 pcs		1/2/18	0.00	1.56	Bandsaw1		17-12-27
110	CNC Vertical Machining	4 pcs		1/2/18	0.36	8.51	HAAS1-3		17-12-27
120	QC	4 pcs		1/2/18	0.00	0.00	QC2 Machining-1		17-12-27
130	QC	4 pcs		1/2/18	0.00	0.00	QC8 Machining-1		18/01/20
140	Small Fab	4 pcs		1/3/18	0.00	0.22	Small Fab-2		18/01/20
150	QC	4 pcs		1/3/18	0.00	0.00	QC5		18/01/20
160	Packaging	4 pcs		1/3/18	0.00	0.00	Packaging3-1	57018	18/01/20
170	QC21-SA	4 Ea		1/3/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks: (1.250" x 2.000") 4.425" long → 135447

Descriptions: 110 - 1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114

140 - Assemble D3121-143 as per Dwg D3121.

JAN 22 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3121-241 5024941	8	25	0	0
140-Small Fab	D3121-21 F150589	8	50	0	0
	M17-4-B1.250X02.000	1	9	0	0

Part Specifications

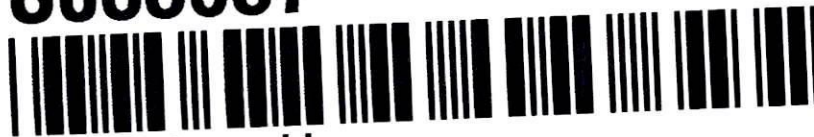
Specifications could not be found.

Plex 12/8/17 10:24 AM dart.poulin.mario

M174 B2.500 x 1.250
Fm135447

DART
AEROSPACE
S033637

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CANADA
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Bracket Assembly

PART NO: D3121-144

Original Serial #: S033637

Revision:

Operation:

Change No:

Start up Operation 01/19/18

Job No: 169363

DART AEROSPACE LTD		Work Order:	1169363
Description: Bracket		Part Number:	D3121-114
Inspection Dwg: D3121 Rev: E		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.080	/			
0.300	+/-0.010	.300	/			
R0.375	+/-0.010	.375	/			
1.54	+/-0.030	1.54	/			
0.350	+/-0.010	.350	/			
R0.25	+/-0.030	.25	/			
Ø0.392	+0.002/-0.000	.3934	/			
Ø0.201	+/-0.010	.200	/			
0.100	+/-0.010	.099	/			
2.540	+/-0.010	2.538	/			
1.590	+/-0.010	1.589	/			
0.160	+/-0.010	0.160 .163	/			
0.400	+/-0.010	.400	/			
1.220	+/-0.010	1.220	/			
1.600	+/-0.010	1.603	/			
3.80	+/-0.030	3.794	/			
1.800	+/-0.010	1.801	/			
R0.50	+/-0.030	.50	/			
0.130	+/-0.010	.129	/			
3.41	+/-0.030	3.391	/			
3.65	+/-0.030	3.65	/			
2.24	+/-0.030	2.21	/			
45°	+/-0.1°	45°	/			
R0.25	+/-0.030	.25	/			
3.97	+/-0.030	3.961	/			
R0.38	+/-0.030	.375	/			
Ø0.392	+0.002/-0.000	.393	/			
Ø0.201	+/-0.010	.200	/			
0.268	+/-0.010	.268	/			
R0.260	+/-0.010	.26	/			
0.080	+/-0.010	.080	/			
0.300	+/-0.010	.300	/			
0.381	+/-0.010	.380	/			
0.201	+/-0.010	.201	/			
0.580	+/-0.010	.580	/			



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D3121-144 Revision: Bracket Assembly														
170	QC21-SA	S033637	169363	4 Ea	0	S033637	ST018	Bin	Stock	1/19/2018	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Part Number: M17-4-B2.500X1.250 Revision: 17-4 SS Bar 2.500 x 1.250														
100	Receive Ft	S033634	169363	0 ft	0	M135447	MAT	Bin	Stock	1/19/2018	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		4	0									

Plex 1/22/2018 3:16 PM Dart.Lajeunesse.Marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					